

Date: Wednesday, 23/07/2008 12:47:44 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|-----------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 412 GROSS WEIGHT TOWING KIT |
| Job Number : | 40719 | | |
| Estimate Number : | 12592 | | |
| P.O. Number : | | Part Number : | D412666011 |
| This Issue : | 23/07/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D412-666 REV C |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 37166 | Drawing Revision : | C |
| Written By : | | Material : | |
| Checked & Approved By : | JLD 08.7.23 | Due Date : | 30/07/2008 |
| Comment : | Est Rev:B Added GHG 002 NG 02-03-06 | Qty: | 4 |
| | Est Rev:C As per Rev C JLM 07-09-07 Verified By:EC | Um: | Each |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: Photocopy bluefile & type labels per PPP412-666-011 CHG 004

JS 08/08/07

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

| | | |
|-----|-------|-----|
| 3.0 | D2888 | Lug |
|-----|-------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug
 Batch: 46733

JS 08/08/07 (x4)

| | | |
|-----|--------|------|
| 4.0 | AN615A | Bolt |
|-----|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt
 Batch: M102832 x15 M108744 x1

JS 08/08/07 (x4)

| | | |
|-----|--------|------|
| 5.0 | AN645A | Bolt |
|-----|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt
 Batch: M106516 x6 M107378 x10

JS 08/08/07 (x4)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 23/07/2008 12:47:44 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 GROSS WEIGHT TOWING KIT

Job Number: 40719

Part Number: D412666011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Batch: M167959

JS 08/08/07 (4)

7.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Batch: M108077

JS 08/08/07 (4)

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/08/07 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-666-011

Location:

PPP Rev: D

JS 08/08/07 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/08/08 MF 08-08-08 (4)

Job Completion



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

| QTY -011 | PART | DESCRIPTION |
|-------------|--------------|-------------------------|
| X | D412-666-011 | GROSS WEIGHT TOWING KIT |
| 2 | D2888 | LUG |
| 4 | AN6-15A | BOLT |
| 4 | AN6-45A | BOLT |
| 8 | AN960JD616 | WASHER |
| 4 | MS21042L6 | NUT (or MS21042-6) |

△

3.0 WEIGHT AND BALANCE:

| INSTALLATION | WEIGHT | LONGITUDINAL | |
|--------------|--------------------|--------------------|------------------------|
| | | ARM | MOMENT |
| D412-666-011 | 1.90 lb 0.86 kg | 163.0 in 4.14 m | 310 in lb 3.56 m kg |

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

△ 5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

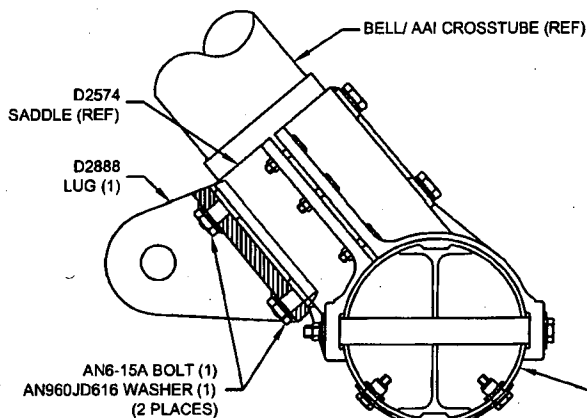


FIGURE 1
(BELL/AAI CROSSTUBES)

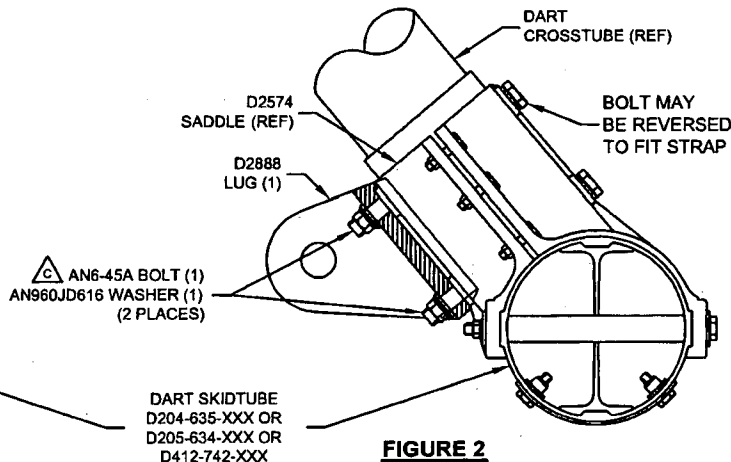


FIGURE 2
(DART CROSSTUBES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40719

| C | - AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED | MB | 07.08.09 |
|------------|--|--|--------------|
| B | UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES | CP | 02.03.04 |
| A | NEW ISSUE | CP | 99.05.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>[Signature]</i> | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | N/A | D412-666 | SHEET 1 OF 1 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 412 GROSS WEIGHT TOWING KIT | 1:4 |
| DATE | 07.08.10 | COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

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| Job Number | : 40719 | | |
| Estimate Number | : 12592 | | |
| P.O. Number | : | Part Number | : D412666011 |
| This Issue | : 23/07/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D412-666 REV C |
| First Issue | : // | Project Number | : N/A |
| Previous Run | : 37166 | Drawing Revision | : C |
| Written By | : | Material | : |
| Checked & Approved By | : <u>JD 08.7.23</u> | Due Date | : 30/07/2008 |
| Comment | : Est Rev:B Added GHG 002 NG 02-03-06 | Qty: | 4 |
| | Est Rev:C As per Rev C JLM 07-09-07 Verified By:EC | Um: | Each |

Additional Product

REFERENCE ONLY

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



JD 08.8.07



Comment: Photocopy bluefile & type labels per PPP412-666-011 CHG 004

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

| | | |
|-----|-------|-----|
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|-----|-------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Lug
 Batch: _____

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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Bolt
 Batch: _____

| | | |
|-----|--------|------|
| 5.0 | AN645A | Bolt |
|-----|--------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Bolt
 Batch: _____